Owing to the fact that the majority of counterfeit coins in circulation are Fifty Cent pieces, the public are more prone to inspect coins of this denomination, and for this reason some careful counterfeiters are content to turn out coins of smaller value.

The moulds in which counterfeit coins are cast are usually made from plaster of paris. However, occasionally metal moulds are also used, these can only be made by an expert and are more desirable than the plaster of paris mould, furthermore castings made in a metal mould are much harder than those made in a plaster or sand mould. Both consist of two sections, one of which contains the reverse impression of one side of the coin and the milled edge, while the other bears that of the opposite side of the coin. The two sections of the mould are so made that the same parts are always in contact when fitted together. They contain the pour and vent holes through which the molten metal is poured and the air and gasses escape.

In the manufacture of a counterfeiting mould a genuine coin is used to impart the impression to the plaster and the coin to be used for this purpose is selected carefully by a counterfeiter. Some prefer to use an old coin, such as one bearing the image of King Edward, because as such a coin is somewhat worn and smooth it does not matter so much if the design on the counterfeit is not as clear as it might be, and the public are less likely to question the authenticity of a coin which appears to have been in circulation for some time. To give such a coin an appearance of wear a counterfeiter sometimes places a number of them in a small sack and shakes them, while to remove the shiny appearance he may bury them in the ground for a short time.

The average plaster mould will only make from ten to twenty coins before cracking or becoming too indistinct for further use, and owing to the fact that it is not always possible to obtain another master coin, as the model is called, without some difficulty, a counterfeiter often places this coin to one side ready for use when the time comes to make another set of moulds. When making searches or arrests in cases of this kind it is always very important for the investigator to look for the master coin, as it will invariably be found to bear scratches and the other markings that coins in circulation, even for a short time, accumulate. Just as the pattern formed by the ridges on the finger tips afford positive identification of an individual, so the scratches and markings on a coin form a means of identifying it. The scratches on the master coin are transferred as truly and faithfully to the mould, and in turn from it to the counterfeit coin, as are the image of the King and date of the coin. From this it can be seen how an apparently harmless genuine coin found in the pocket of a suspected counterfeiter may afford evidence whereby he can be linked to the moulds, which might be found in the room of an accomplice in another part of the city, as well as to counterfeit coins found on the premises of the suspect or his accomplice, and also to similar counterfeit coins passed in the city for months past and turned over to the police by those receiving them.

The equipment required for the manufacture of spurious coins is quite simple and easily obtainable. All the heat necessary can be supplied by an ordinary gas stove, hence there is no need for counterfeiters to use specially equipped workshops. As a rule the coiner works in a cheap housekeeping